

Work Order ID 77603

77603

Page 1

Tuesday, December 13, 2011 2:48:07 PM

Item ID: D4278-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Rib Assembly-Hoop
 Start Date: 12/13/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/5/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: *12-13* Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4034	B
D4278	C

100 Weld per dwg A/R S.S. rod Batch: *118366* 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Assemble ribs to hoop and weld as per dwg DT
 2- Weld bushing in rib and grind weld flush as per dwg

14 *[Signature]* *12-05-09*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

1 *[Signature]* *12-05-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Tuesday, December 13, 2011 2:48:08 PM

Item ID: D4278-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Rib Assembly-Hoop
 Start Date: 12/13/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/5/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120		0.00							
QC	Memo								
Quality Control									
130	Identify as per dwg & Stock Location: WA	0.00							
130		0.00							
Packaging	Memo								
Packaging	***STOCK IN BASKET CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
140		0.00							
QC	Memo								
Quality Control									

Handwritten notes and signatures:
 1x *[Signature]* 12/05/09
 12/5/9 *[Signature]*
 MW 12/05/09

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 13, 2011 2:48:12 PM

Page 1

Work Order ID: 77603

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Parent Item: D4278-041

D4278-041

Parent Item Name: Upper Rib Assembly-Hoop

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-7

Manufactured

No

100

Each

8.0000

1

1

D4021-7

Hoop

**

Location

Loc Qty

Loc Code

WA005

8

74807

8

B82704 → ①

D4021-9

Manufactured

No

100

Each

106.0000

4

4

D4021-9

Bushing

**

Location

Loc Qty

Loc Code

WA005

106

66437

2

70333

4

72482

36

74966

64

B82348 → ④

D4034-1

Manufactured

No

100

Each

9.0000

1

1

D4034-1

Rib

**

Location

Loc Qty

Loc Code

WA006

9

74780

9

B81467 → ①

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Picklist Print

Page 2

Tuesday, December 13, 2011 2:48:12 PM

Work Order ID: 77603

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Parent Item: D4278-041

D4278-041

Parent Item Name: Upper Rib Assembly-Hoop

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 1.00

Required Qty: 1.00

D4034-3

Manufactured No

100

Each

3.0000

1

1

D4034-3

Rib

**

Pl 12.05.08

Location

Loc Qty

Loc Code

WA006

3

72253

2

74918

1

382982 → ①

Tuesday, December 13, 2011 2:48:12 PM

Shop Packet Print

Page 2

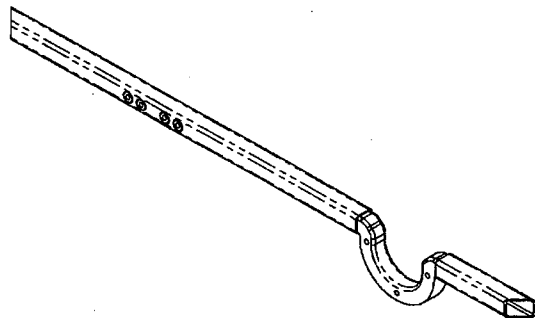
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

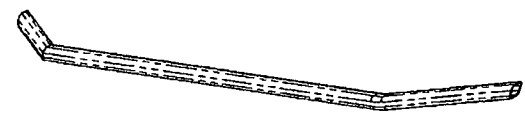
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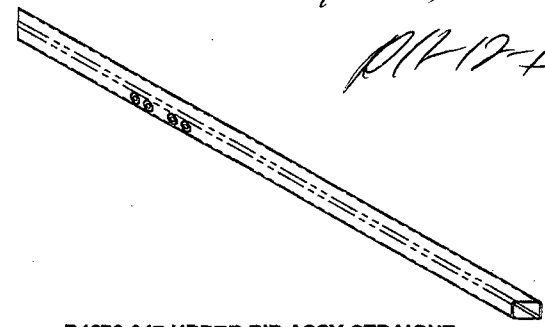
NOTE: Date & initial all entries



D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT



SHOP COPY
 RETURNED
 ENGINEER
 UNCONTROLLED COPY
 SUBJECT TO
 WITHOUT
 WORK ORDER
 NO. *77603*

PIF-17-B

RELEASED
 2011-01-18
MM

C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4278	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

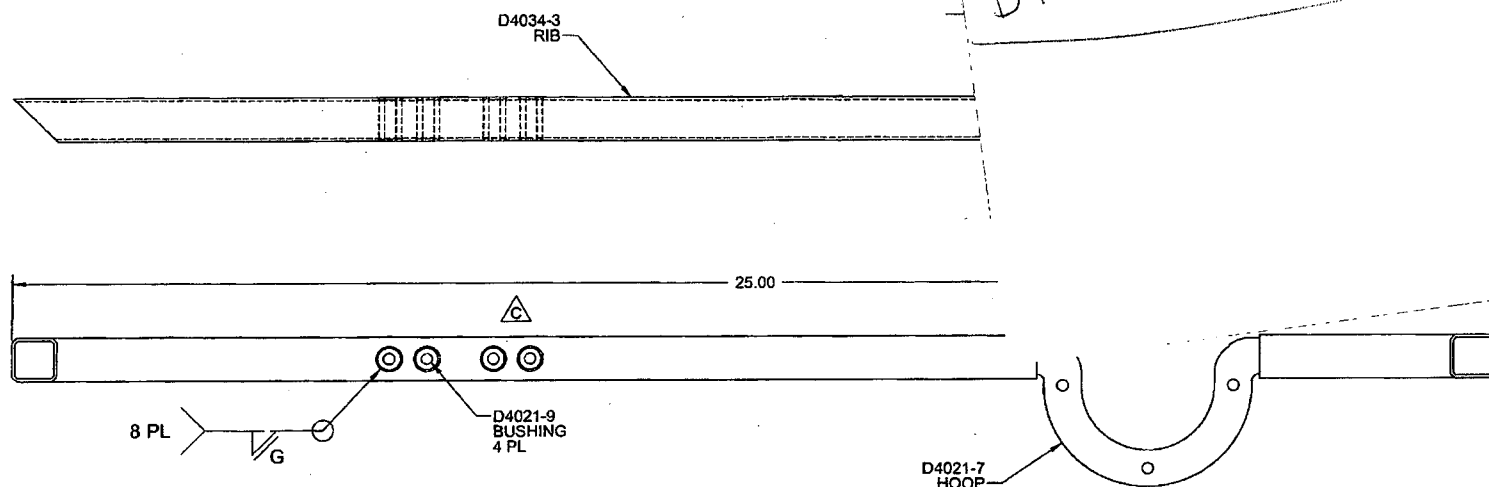
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	1	D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	JRH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 2 OF 4
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

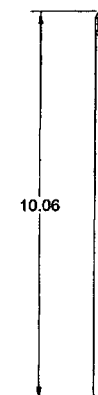
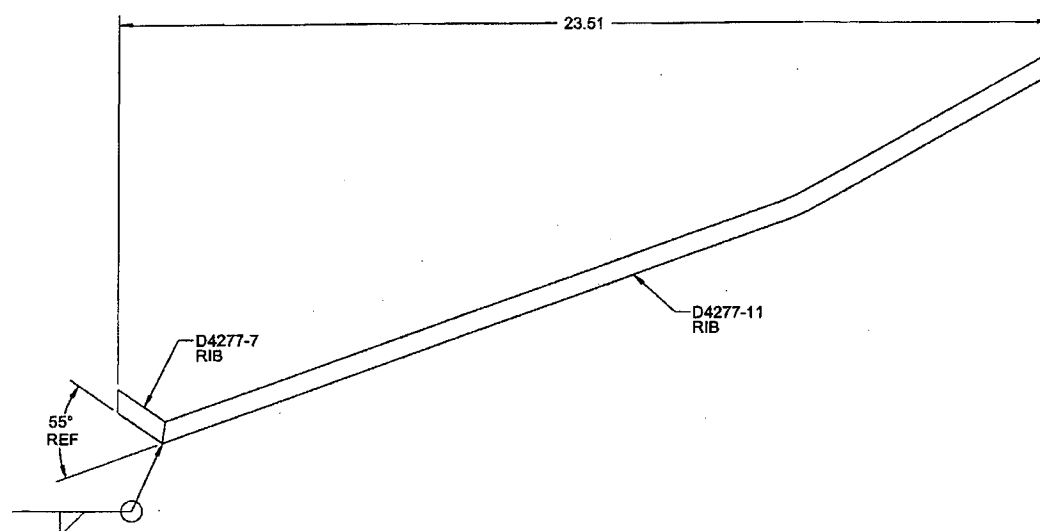
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	1	D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB






D4278-045 RIB ASSY, FWD CHAM

77603

RELEASED
R 2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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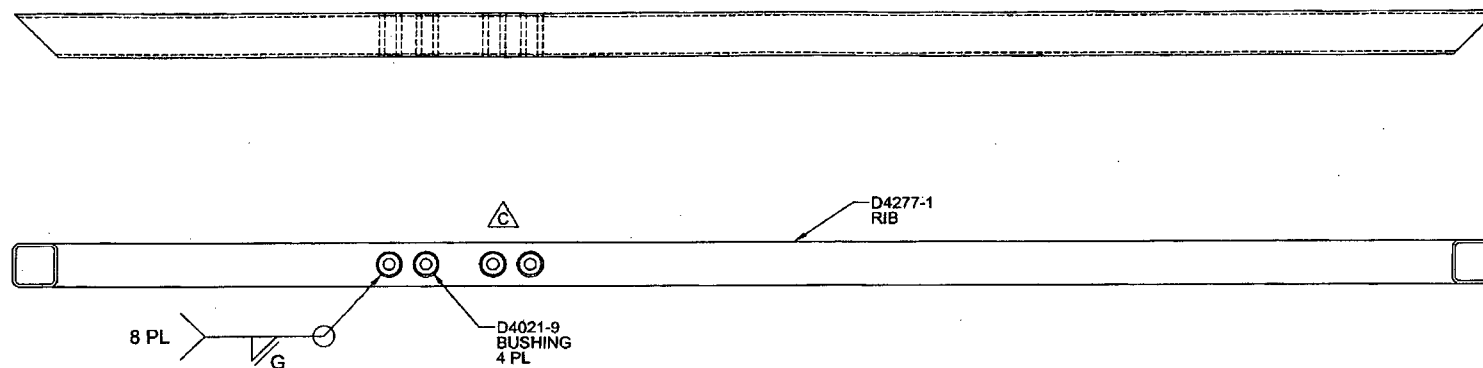
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NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	1	D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

77603

RELEASED
2011-01-10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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